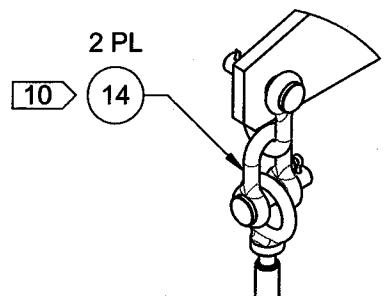
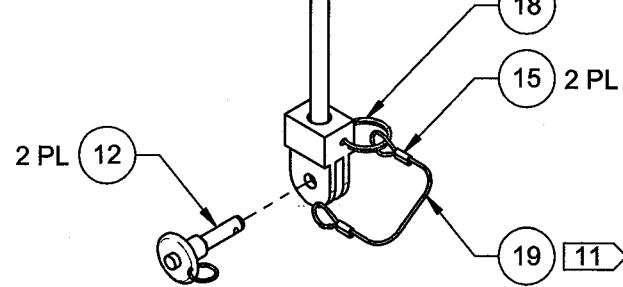
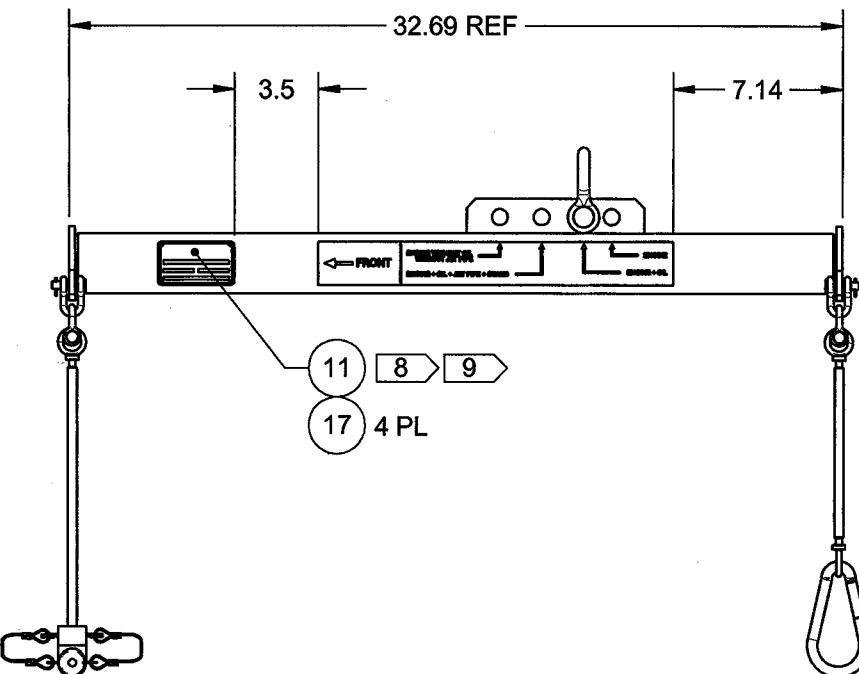
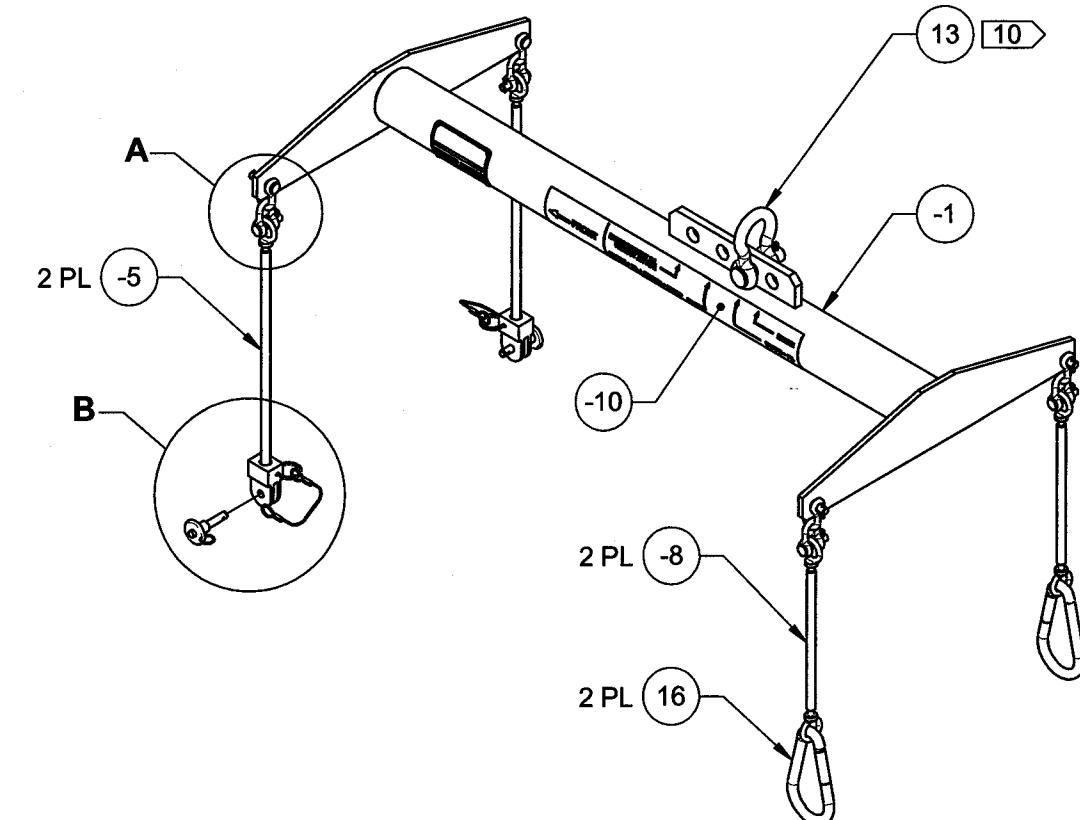


ITEM #	QTY	PART #	PART TITLE
-1	1	RBE332A91-5490-00-1	SLING WELDMENT
-5	2	RBE332A91-5490-00-5	LEFT HAND ROD WELDMENT
-8	2	RBE332A91-5490-00-8	RIGHT HAND ROD WELDMENT
-10	1	RBE332A91-5490-00-10	STICKER
11	1	RB41011	DART PLACARD
12	2	MS17984C508	SS QUICK RELEASE PIN 5/16" DIA. X 0.800" GRIP LG.
13	1	NAS1042-8	ZINC PLATED STEEL ANCHOR SHACKLE 13/16" OPENING WIDTH X 2830 LBS. MAX. WORKING LOAD
14	8	NAS1044-4	ZINC PLATED STEEL CHAIN SHACKLE 15/32" OPENING WIDTH X 710 LBS. MAX. WORKING LOAD
15	4	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
16	2	McMaster#3933T18 OR EQUIV.	ZINC PLATED STEEL CARABINER 5/8" OPENING WIDTH X 800 LBS. CAPACITY
17	4	McMaster#90081A077 OR EQUIV.	ZINC PLATED STEEL SCREW NAIL #2 SIZE X 1/4" LG.
18	2	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
19	A/R	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.

DETAIL A
4 PLDETAIL B
2 PL**RBE332A91-5490-00 MAKILA 2A SLING TOOL**

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: ENGRAVE THE TOOL P/N, S/N, AND "SWL: 720 LBS" ON THE DART PLACARD WHERE INDICATED
- 7) ASSEMBLE AS SHOWN
- 8) FORM ITEM 11 TO OUTER DIAMETER OF ITEM -1 BEFORE INSTALLATION
- 9) TRANSFER DRILL HOLES FOR ITEM 17 THROUGH ITEM -1 TO INSTALL ITEM 11
- 10) BEND COTTER PIN PRONGS OF ITEMS 13 AND 14 AROUND SHACKLE PIN
- 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 12

A	SEE CAR 19-354 FOR DETAILED EXPLANATION OF CHANGES MADE	19-1027	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT		
DRAWN	KPT		
CHECKED	PM		
MFG. APPR.	DP		
APPROVED	W/O		
DATE	1/10/2020		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART # **RBE332A91-5490-00**

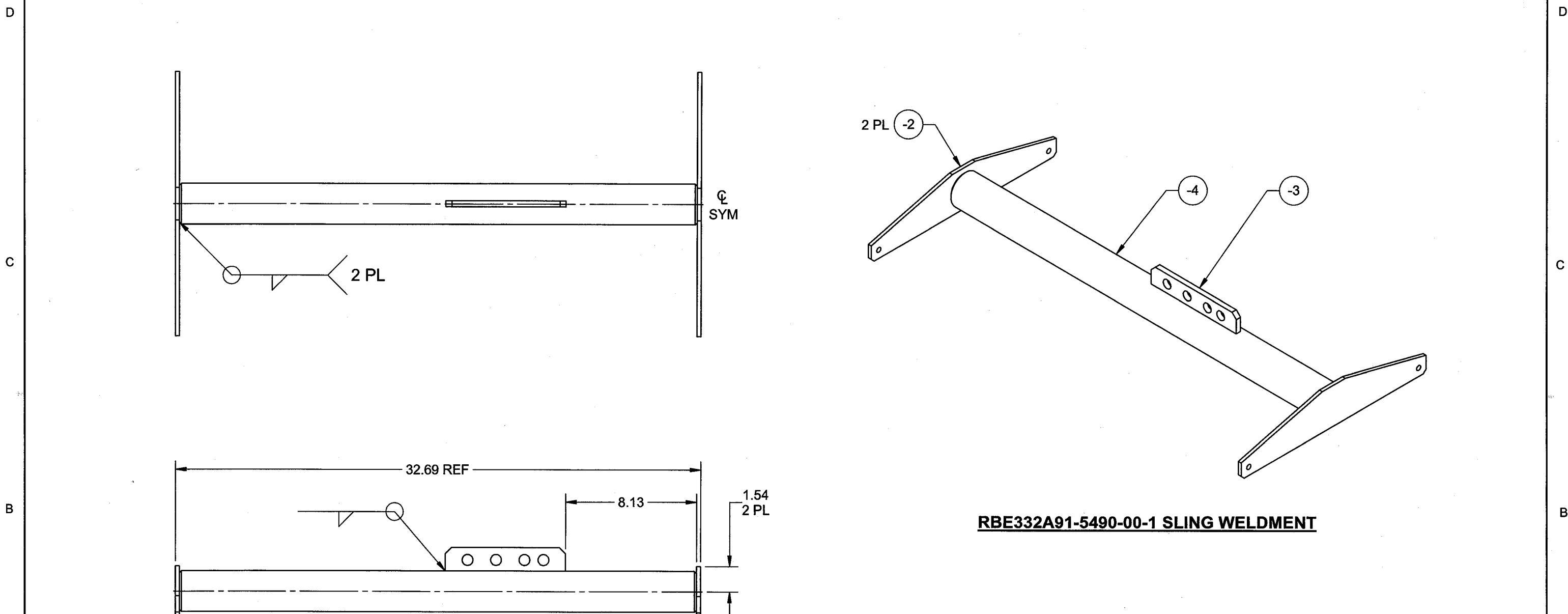
REV. A
SHEET 1 OF 12

TITLE **MAKILA 2A SLING TOOL**

SCALE **NTS**

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ITEM #	QTY	PART #	PART TITLE
-2	2	RBE332A91-5490-00-2	END PLATE
-3	1	RBE332A91-5490-00-3	LIFT PLATE
-4	1	RBE332A91-5490-00-4	PIPE



RBE332A91-5490-00-1 SLING WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	NO
DATE	1/10/2020

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 REV. A
 SHEET 2 OF 12
 TOOL PART #
RBE332A91-5490-00
 TITLE
MAKILA 2A SLING TOOL
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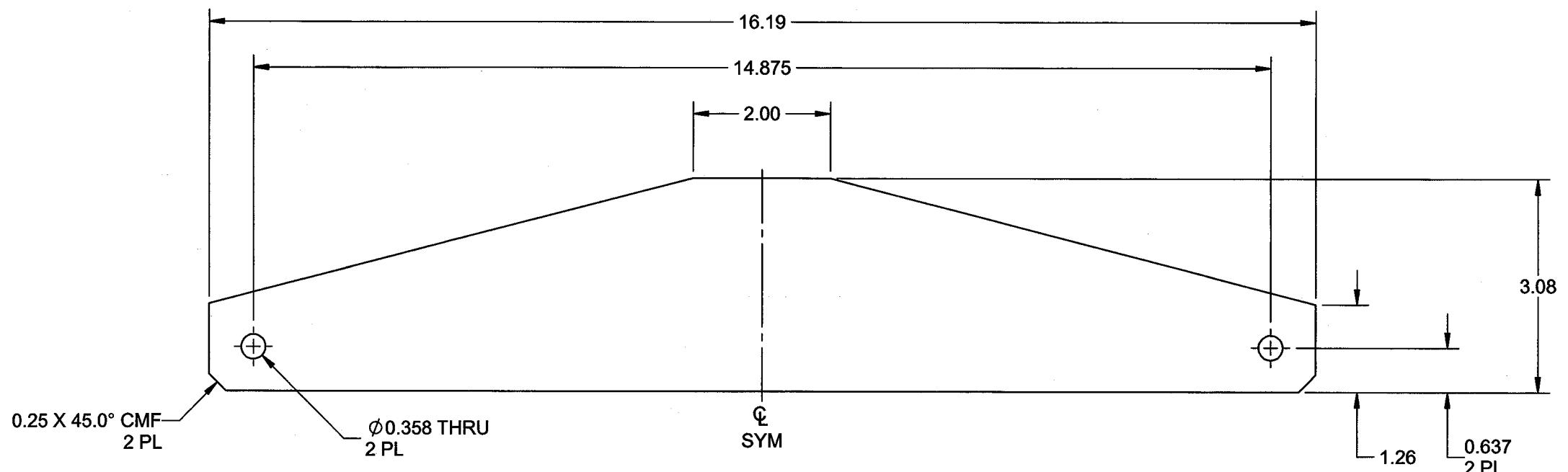
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RBE332A91-5490-00-2 END PLATE

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	N/S
DATE	1/10/2020

TOOL PART #	RBE332A91-5490-00
REV. A	
SHEET 3 OF 12	
SCALE	NTS

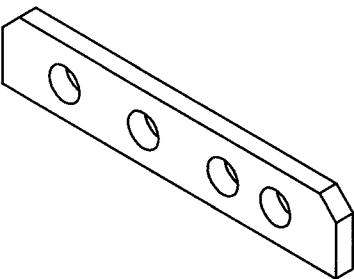
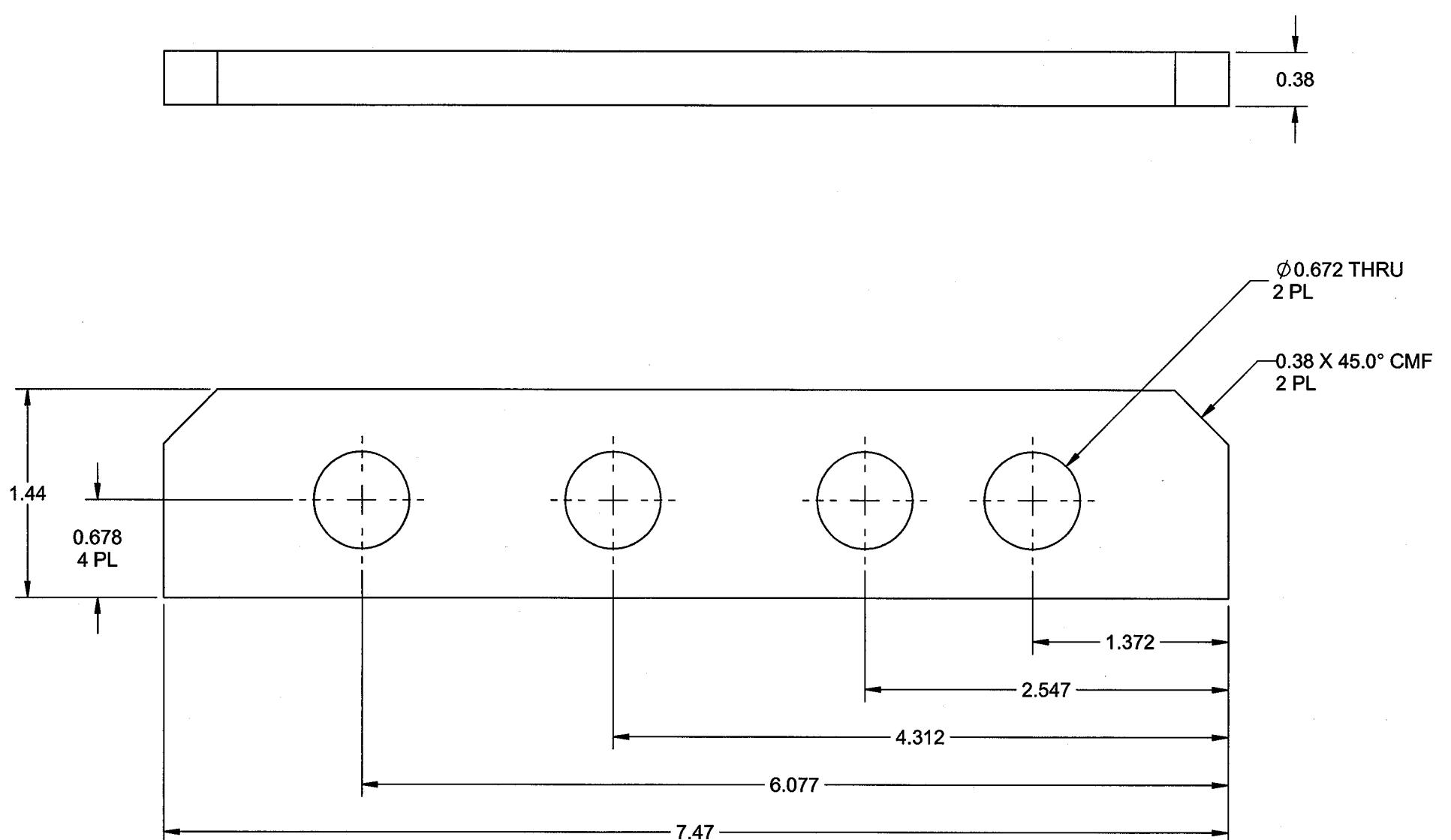
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

MAKILA 2A SLING TOOL

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RBE332A91-5490-00-3 LIFT PLATE

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	W0
DATE	1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
TOOL PART # RBE332A91-5490-00
TITLE MAKILA 2A SLING TOOL
REV. A: SHEET 4 OF 12
SCALE NTS

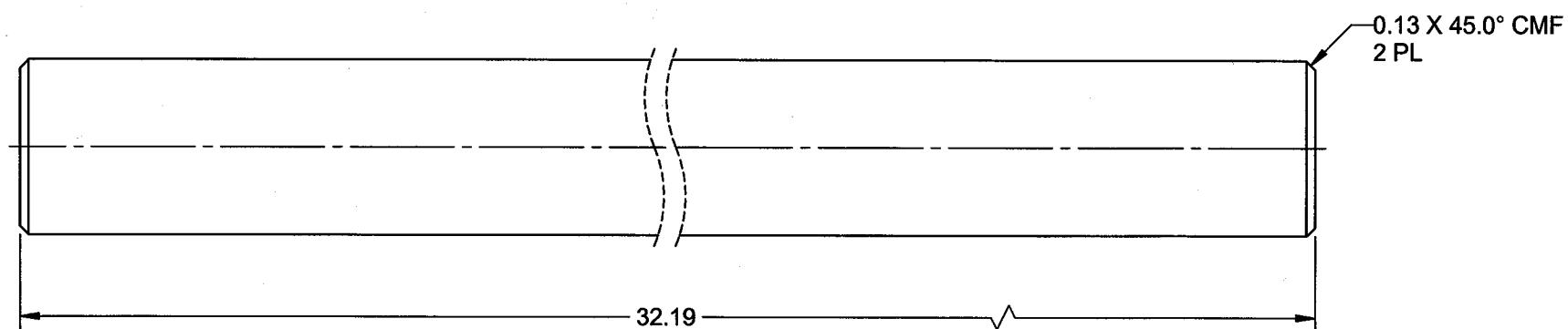
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RBE332A91-5490-00-4 PIPE

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NOTES:

- 1) MATERIAL: A519 CDS TUBING
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 $X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$$
 $X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$$
 $X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	M0
DATE	1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

REV. A

TOOL PART # **RBE332A91-5490-00**

SHEET 5 OF 12

SCALE NTS

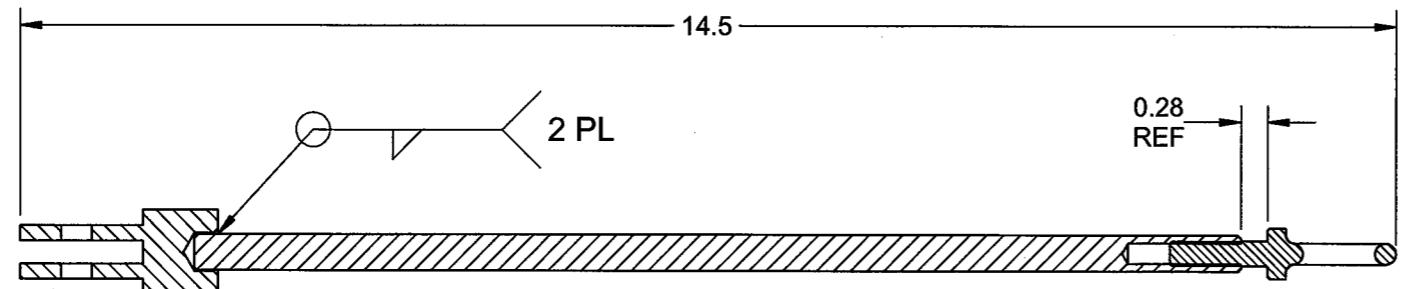
MAKILA 2A SLING TOOL

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ITEM #	QTY	PART #	PART TITLE
-6	1	RBE332A91-5490-00-6	LEFT HAND ROD
-7	1	RBE332A91-5490-00-7	CLEVIS
20	1	MS51937-21	UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG.

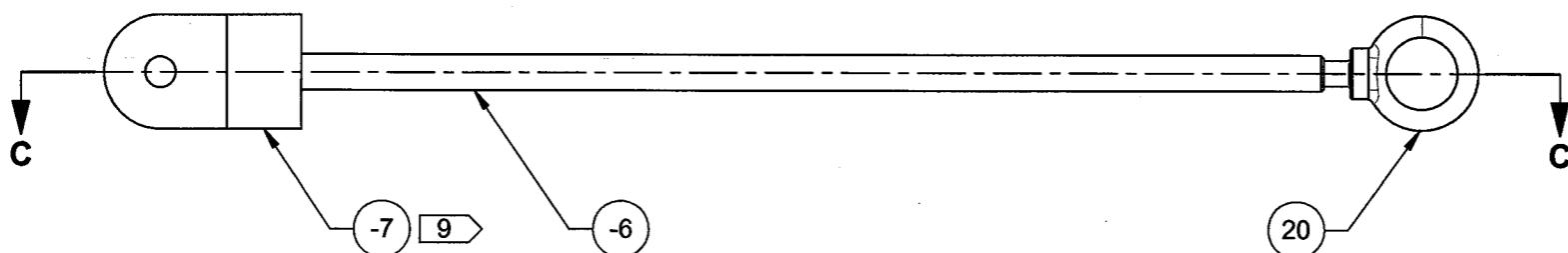
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SECTION C-C

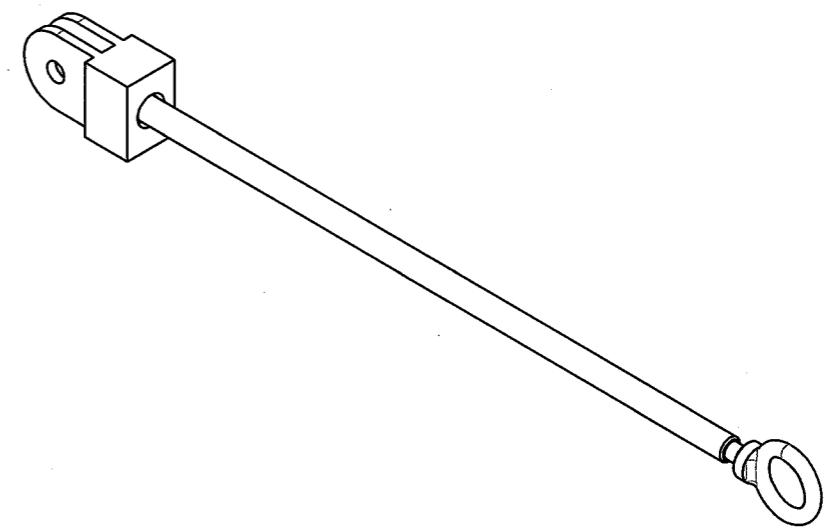
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RBE332A91-5490-00-5 LEFT HAND ROD WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS
- 9) MASK HOLES AND SLOTS OF ITEM -7 PRIOR TO POWDERCOAT FINISH

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	VO

DATE 1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBE332A91-5490-00

TITLE
MAKILA 2A SLING TOOL

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REV. A

SHEET 6 OF 12

SCALE
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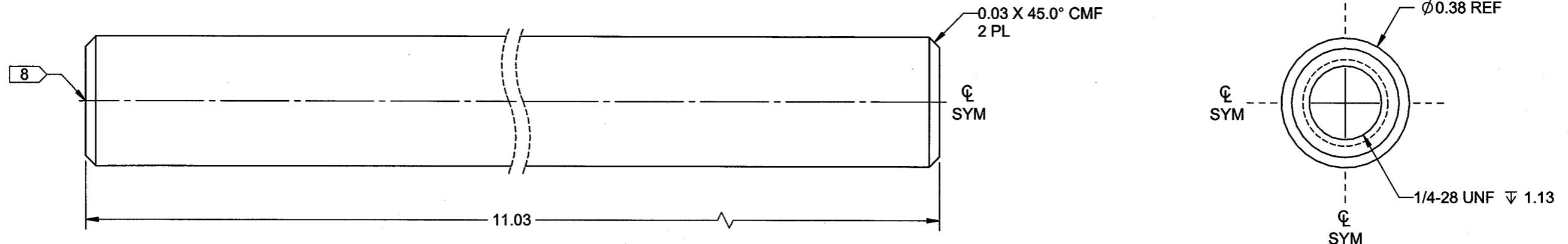
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RBE332A91-5490-00-6 LEFT HAND ROD

NOTES:

- 1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)
- 2) HEAT TREAT: 28-32 RC
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	W/O
DATE	1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBE332A91-5490-00

REV. A

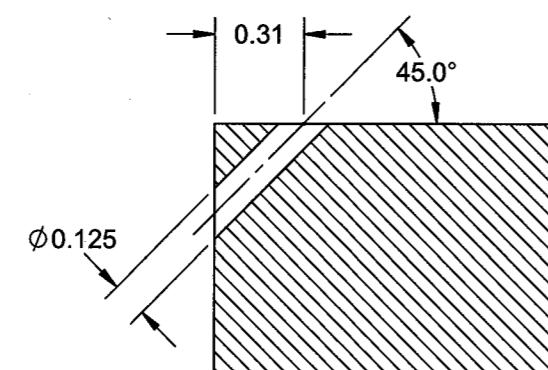
SHEET 7 OF 12

TITLE
MAKILA 2A SLING TOOL

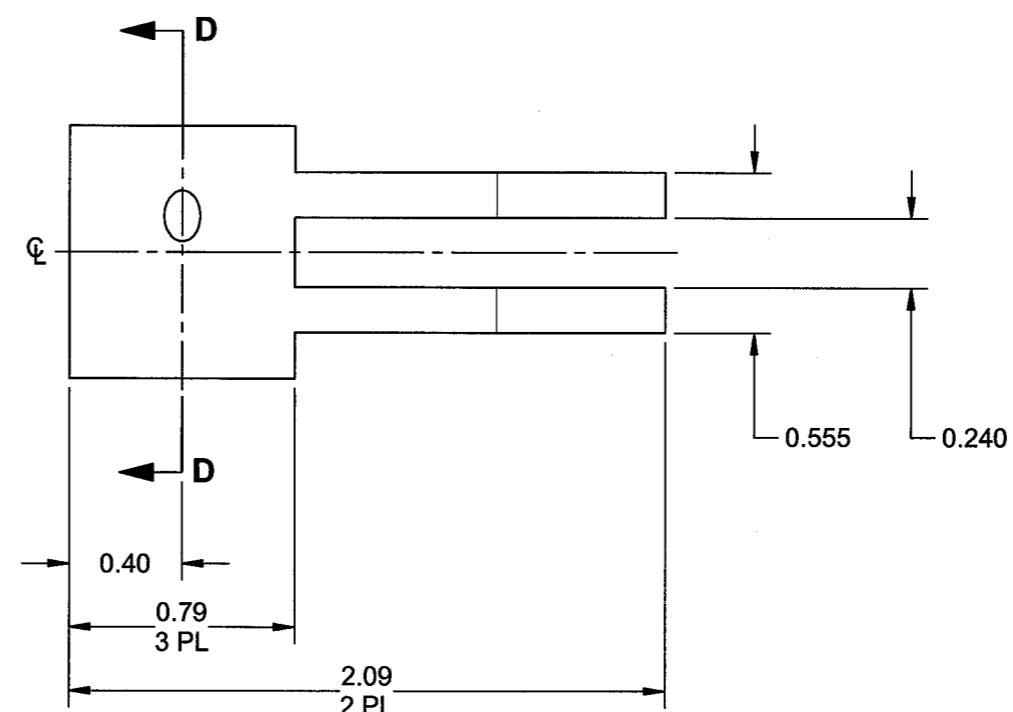
SCALE
NTS

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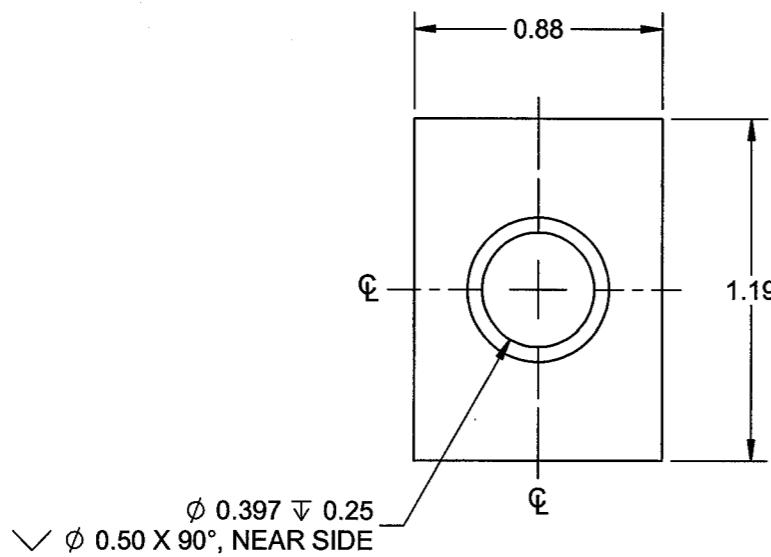
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**SECTION D-D**

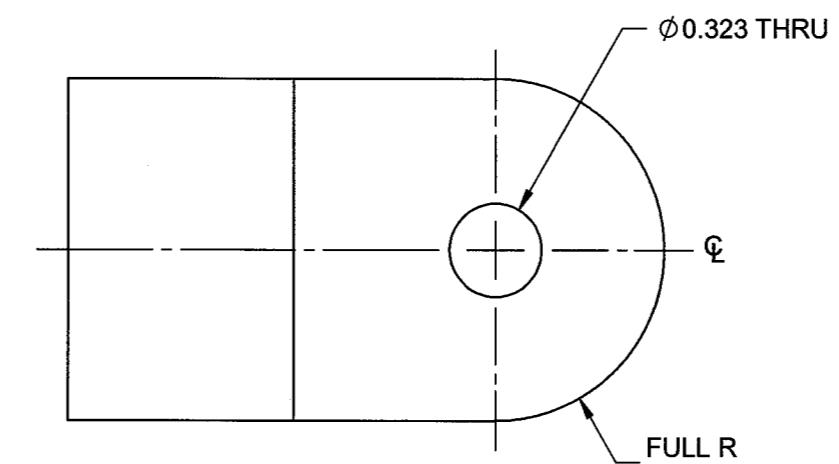
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✓ ϕ 0.397 \downarrow 0.25
 \vee ϕ 0.50 X 90°, NEAR SIDE

**RBE332A91-5490-00-7 CLEVIS****NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $+\/- 0.1"$ / $+\/- 1^\circ$
 X.XX = $+\/- 0.01"$ / $+\/- 0.5^\circ$
 X.XXX = $+\/- 0.005"$ / $+\/- 0.1^\circ$
 X.XXXX = $+\/- 0.0005"$ / $+\/- 0.05^\circ$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+\/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	WCO
DATE	1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBE332A91-5490-00

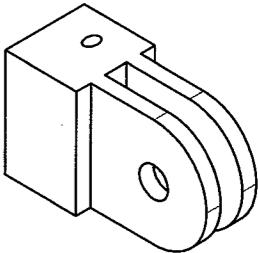
REV. A

SHEET 8 OF 12

TITLE
MAKILA 2A SLING TOOL

SCALE
NTS

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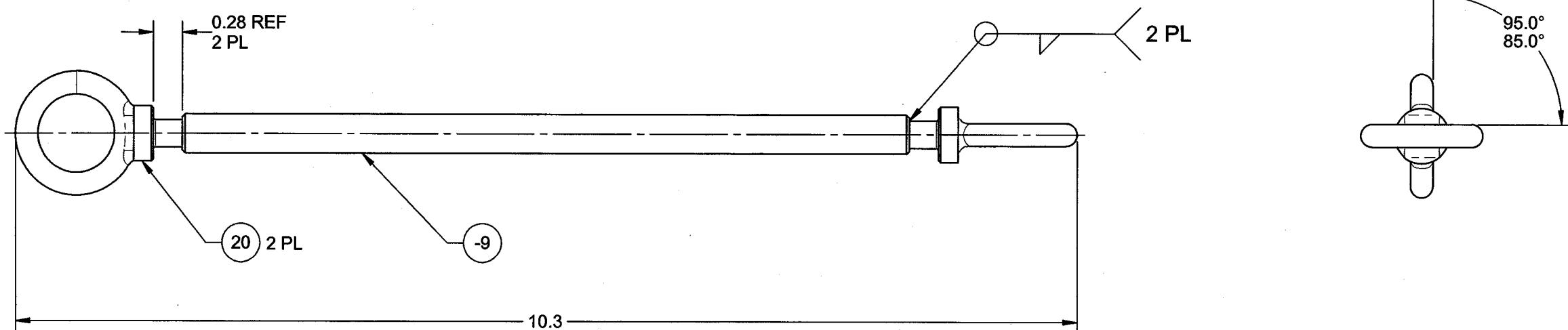
ITEM #	QTY	PART #	PART TITLE
-9	1	RBE332A91-5490-00-9	RIGHT HAND ROD
20	2	MS51937-21	UNCOATED STEEL EYE BOLT 1/4"-28 X 1-1/32" SHANK LG.

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RBE332A91-5490-00-8 RIGHT HAND ROD WELDMENT

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: POWDERCOAT YELLOW QSI 005 OR MIL-PRF-24712
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) REMOVE ALL WELD SPATTERS

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	ND
DATE 1/10/2020	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
TOOL PART #
RBE332A91-5490-00
TITLE
MAKILA 2A SLING TOOL

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REV. A

SHEET 9 OF 12

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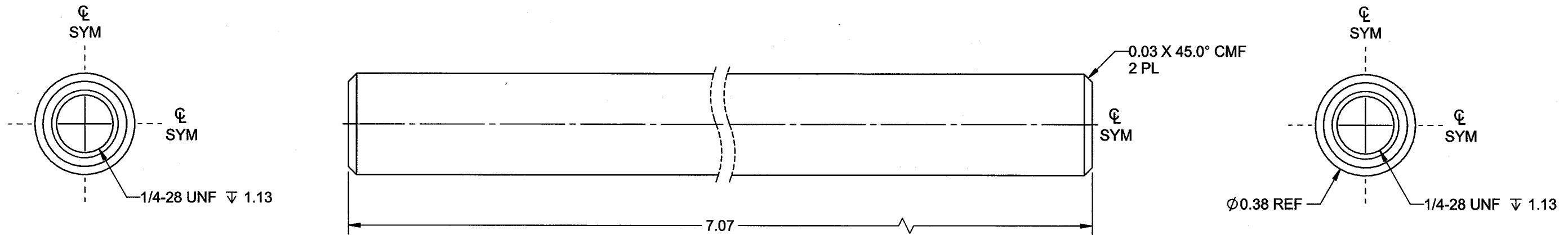
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RBE332A91-5490-00-9 RIGHT HAND ROD

NOTES:

- 1) MATERIAL: McMaster#5252T315 OR EQUIV. (4140 ALLOY STEEL 3/8" DIA. ROD)
- 2) HEAT TREAT: 28-32 RC
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	NO
DATE	1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #
RBE332A91-5490-00

REV. A

SHEET 10 OF 12

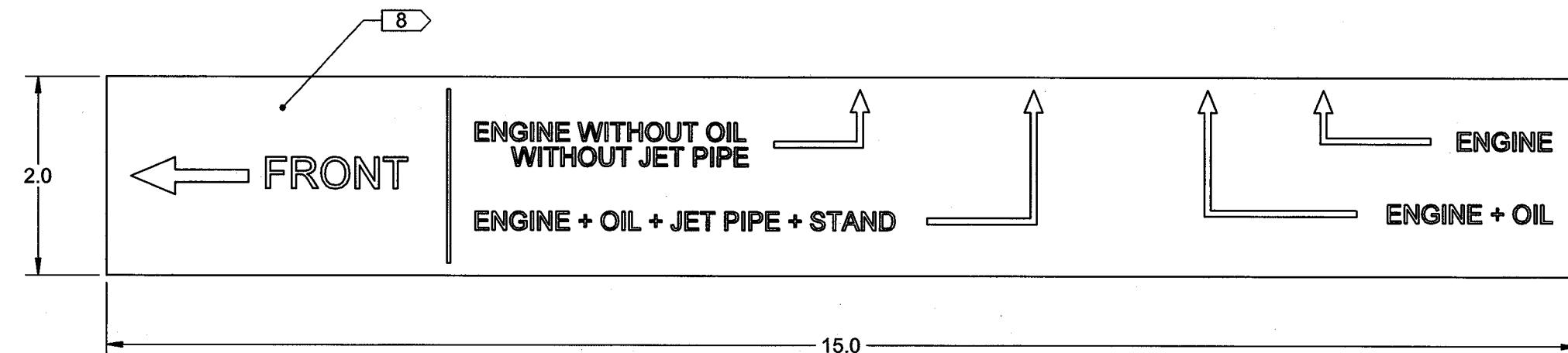
TITLE
MAKILA 2A SLING TOOL

SCALE
NTS

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RBE332A91-5490-00-10 STICKER

9

NOTES:

1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031 OR EQUIV.

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

8) SILVER BACKGROUND WITH BLACK LETTERS AND ARROWS

9) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBE332A91-5490-00-10 REV. A3.DXF

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	NO

DATE 1/10/2020

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

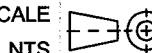
TOOL PART #
RBE332A91-5490-00

REV. A

SHEET 11 OF 12

TITLE
MAKILA 2A SLING TOOL

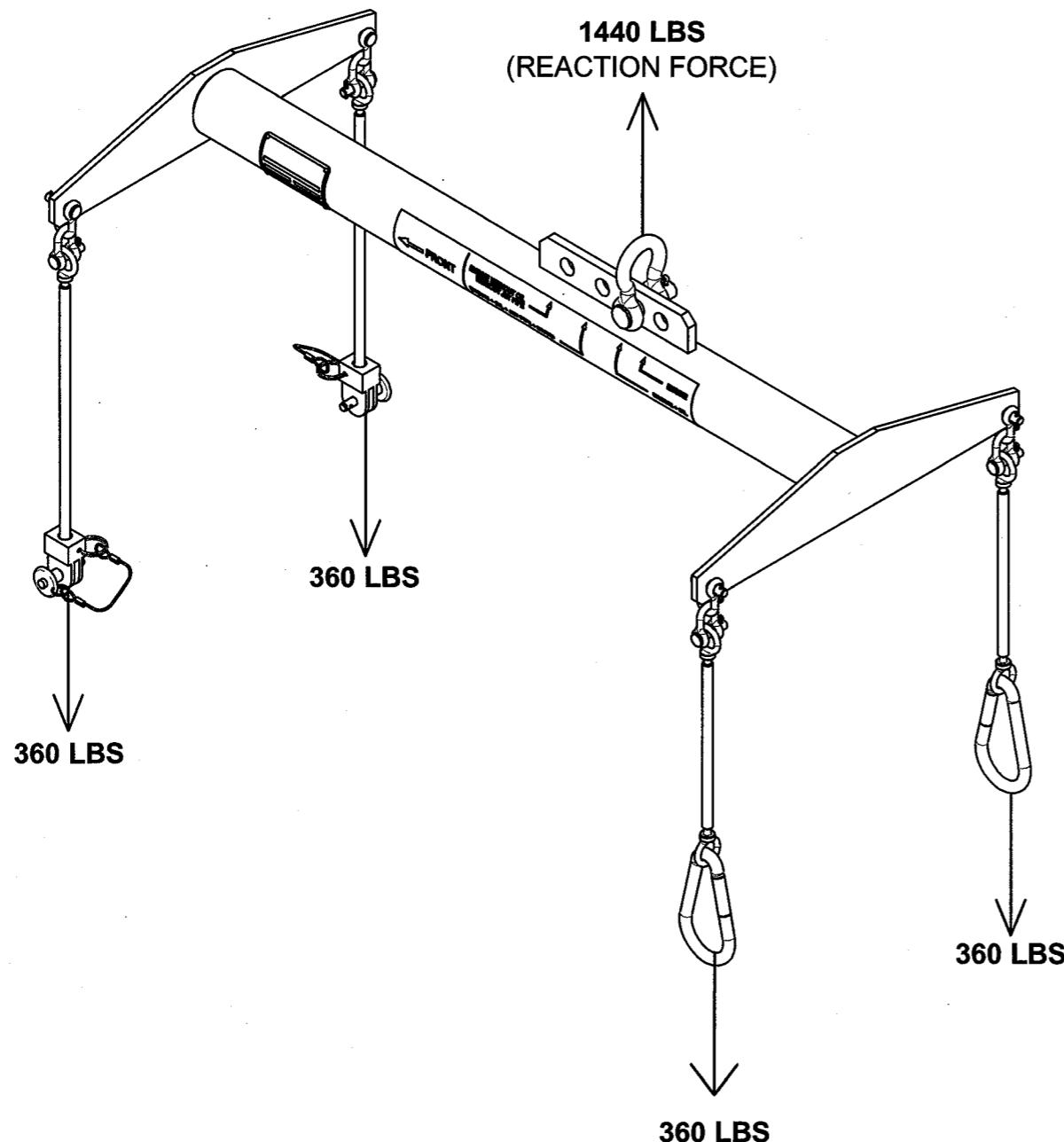
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INSPECTION AND TESTING PROCEDURE FOR THE RBE332A91-5490-00 MAKILA 2A SLING TOOL. THIS ASSEMBLY SHOULD BE INSPECTED BEFORE EACH USE. REPLACE ANY ITEMS THAT ARE DAMAGED OR SUSPECTED OF DAMAGE BEFORE USE.

FIRST ARTICLE WEIGHT TEST

1. AFTER INSPECTION, PLACE SLING ASSEMBLY ON AN OVERHEAD LIFTING DEVICE INTO. ATTACH SLING TO AN APPROPRIATE TEST WEIGHT OF 654 KG / 1440 LBS.
2. LIFT WEIGHT FOR AT LEAST 5 MINUTES, CONTINUALLY CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
3. REMOVE WEIGHT AND RE-INSPECT SLING, CHECKING FOR CRACKS, DEFLECTIONS, AND/OR DISTORTIONS
4. REPEAT STEPS 1 TO 3 FOR "ENGINE WITHOUT OIL WITHOUT JET PIPE", "ENGINE + OIL + JET PIPE + STAND", AND "ENGINE" HOLE POSITIONS

INSPECTOR: _____

TESTER: _____

S/N: _____

DATE: _____

DESIGN	KPT
DRAWN	KPT
CHECKED	PM
MFG. APPR.	DP
APPROVED	MD
DATE 1/10/2020	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
TOOL PART # RBE332A91-5490-00
TITLE MAKILA 2A SLING TOOL

REV. A
SHEET 12 OF 12
SCALE NTS

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